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<p>(21) International Application Number: PCT/US99/20238 (22) International Filing Date: 2 September 1999 (02.09.99) (30) Priority Data: 60/099,176 4 September 1998 (04.09.98) US (71) Applicant: CYTEC TECHNOLOGY CORP. [US/US]; 1105 North Market Street, Wilmington, DE 19801 (US). (72) Inventors: GUPTA, Ram, B.; Unit 30, 511 West Main Street, Stamford, CT 06902 (US). JAKIELA, Dennis, J.; 486 Grace Trail, Orange, CT 06477 (US). VENIMADHAVAN, Sampath; 15 Weatherly Lane, Norwalk, CT 06854 (US). CAP-PADONA, Russell, C.; 63 Valley View Court, Norwalk, CT 06851 (US). PAI, Venkatrao, K.; 63 Westover Lane, Stamford, CT 06902 (US). (74) Agents: SHERWOOD, Michelle, A. et al.; Cytec Industries Inc., 1937 West Main Street, P.O. Box 60, Stamford, CT 06904-0060 (US).</p>		<p>(81) Designated States: AE, AL, AM, AU, AZ, BA, BB, BG, BR, BY, CA, CN, CU, CZ, EE, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, RO, RU, SD, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>With international search report.</i></p>
<p>(54) Title: PROCESS FOR MAKING 2- (2,4- DIHYDROXYPHENYL) OR 2- (2,4- DIALKOXYPHENYL)- 4,6- BISARYL- 1,3,5- TRIAZINES</p> <p>(57) Abstract</p> <p>Provided is a new process for the preparation of compositions containing at least one triazine ultraviolet light absorber.</p>		

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PROCESS FOR MAKING 2-(2,4-DIHYDROXYPHENYL) OR 2-(2,4-DIALKOXYPHENYL)-4,6-BISARYL-1,3,5-TRIAZINES

This application claims the benefit of pending U.S. Provisional Application No. 60/099,176 filed September 4, 1998.

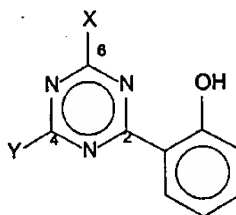
FIELD OF THE INVENTION

This invention relates to a new process for the preparation of 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazines or 2-(2,4-dialkoxyphenyl)-4,6-bisaryl-1,3,5-triazines.

BACKGROUND OF THE INVENTION

Exposure to sunlight and other sources of ultraviolet radiation is known to cause degradation of a wide variety of materials, especially polymeric materials. For example, polymeric materials such as plastics often discolor and/or become brittle as a result of prolonged exposure to ultraviolet light. Accordingly, a large body of art has been developed directed towards materials such as ultraviolet light absorbers and stabilizers which are capable of inhibiting such degradation.

A class of materials known to be ultraviolet light absorbers are triazines. Triazine ultraviolet light absorbers are a class of compounds which have at least one 2-hydroxyphenyl substituent on the 1,3,5-triazine ring.

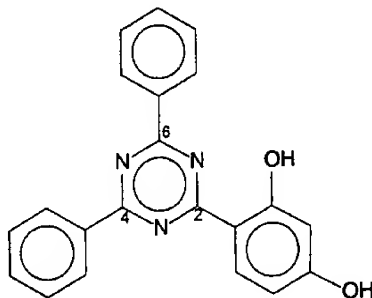


2-(2-Hydroxyphenyl)-1,3,5-triazines

X, Y = substituents

Trisaryltriazine ultraviolet light absorbers are compounds which have aromatic substituents at the 2-, 4- and 6-positions of the 1,3,5-triazine ring, and in which at least one of the aromatic rings has a hydroxyl substituent at the ortho position. These aromatic rings may contain other substituents or may be fused polyaromatics. In general this class of compounds is well known in the art. Disclosures of a number of such trisaryl-1,3,5-triazines, as well as processes for preparing and uses thereof, can be found in the following publications, all of which are incorporated by reference as if fully set forth herein: U.S. patents 3,118,887, 3,242,175, 3,244,708, 3,249,608, 3,268,474, 3,423,360, 4,619,956, 4,740,542, 5,084,570, 5,288,778, 5,461,151, 5,476,937, 5,478,935, 5,543,518, 5,545,836, 5,591,850, and 5,597,854, British patent 1,033,387, Swiss patents 480,091 and 484,695, European patent applications 0,444,323 and 0,649,841, and PCT applications WO94/05645 and WO96/28431.

A commonly used class of trisaryl-1,3,5-triazine ultraviolet light absorbers is based on 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazines. In these compounds two non-phenolic aromatic groups and one phenolic aromatic group are attached to the 1,3,5-triazine. The phenolic aromatic group is derived from resorcinol.

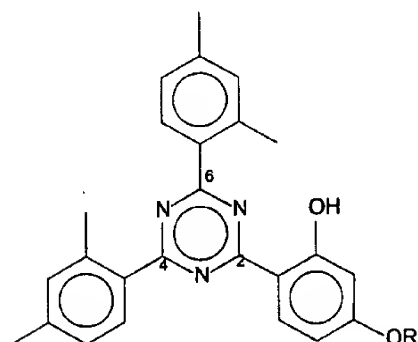


2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazines

Of this class of compounds, a number of commercial examples exist in which the para-hydroxyl group of the phenolic ring is functionalized and the non-phenolic aromatic rings are either unsubstituted phenyl, as in TINUVIN 1577 or meta-xylyl, as in CYASORB UV-1164, CYASORB UV-1164L and TINUVIN 400. These ultraviolet light absorbers exhibit high inherent light stability and permanence as compared to other classes of ultraviolet light absorbers such as benzotriazoles and benzophenones.

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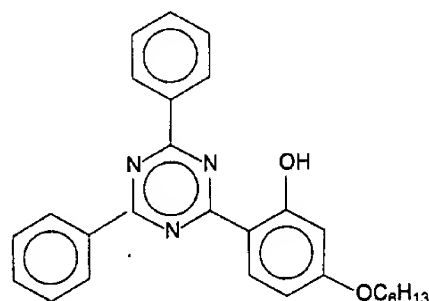
Cyasorb UV 1164: R = n-C₈H₁₇

Cyasorb UV 1164 (L): R = iso-C₈H₁₇

Tinuvin 400: R = CH₂CH(OH)CH₂OCNH₂N₊

N = 12-14

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Tinuvin 1577

25

Several approaches to the production of 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazines have been reported in the literature. For example, H. Brunetti and C.E. Luethi, Helvetica Chimica Acta, vol. 55, pages 1566-1595 (1972), and S. Tanimoto and M. Yamagata, Senryo to Yakahin, vol. 40 (12), pages 325-339 (1995).

The majority of the approaches are based on cyanuric chloride, a readily available and inexpensive starting material. Resorcinol is known to be much more reactive than meta-xylene toward cyanuric chloride, and in Y. Horikoshi et al, Nippon Kagaku Kaishi (3), pages 530-535, (1974), CA

81:152177 it has been reported to form only the bis-resorcinol-monochloro-triazine and/or trisresorcinol triazine even when cyanuric chloride to resorcinol were used in equimolar ratios. U.S. patent 3,270,016 describes the formation of bis-resorcinol monochloro triazine in good yield by reacting cyanuric chloride and resorcinol at about equimolar ratio at room temperature for 10 hours, with no mention of the formation of the mono-resorcinol bischloro triazine. Further, German patent application DE 1,169,947 or GB 884802 as mentioned in U.S. patent 5,726,310, describes uncontrolled exothermic reaction when cyanuric chloride, meta-xylene and aluminum chloride are simultaneously introduced.

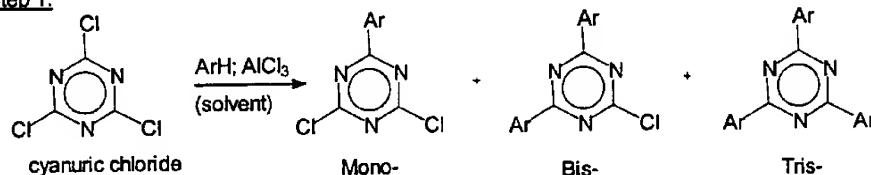
In one method, shown below, cyanuric chloride is reacted with aromatic compounds, such as meta-xylene, in the presence of aluminum chloride. The reaction produces a monochloro-bisaryl-1,3,5-triazine, which is then reacted with resorcinol in a second step to form a 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazine. This process contains several limitations which relate to the first step of the reaction, namely that the first step is not selective and leads to a mixture of all of the possible products, plus unreacted cyanuric chloride. This means that the desired monochloro-bisaryl-1,3,5-triazine must be separated from the reaction mixture before the second reaction step takes place. Another disadvantage is that the first reaction step is not generally applicable to all aromatic compounds. It is well known in the literature that the use of this process gives a useful yield of the desired monochloro-bisaryl-1,3,5-triazine intermediate only when meta-xylene is the aromatic reactant. With other aromatic species, an inseparable mixture of all possible products is formed, and no selectivity for the desired monochloro-bisaryl-1,3,5-triazine is seen. See Brunelli, page 1575. For the meta-xylene based product, an

improved process has recently been disclosed in US5726310, in which the monochloro-bis(2,4-dimethylphenyl)-1,3,5-triazine intermediate produced in the first reaction step is not isolated, but is further reacted with resorcinol in a one-pot, two-step process. This process contains the disadvantage not only of its being applicable only to meta-xylene, but also that it is a two-step process.

SCHEME 1

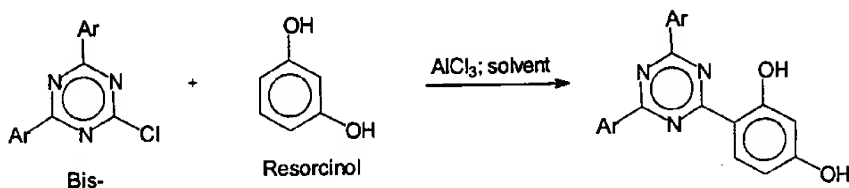
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Step 1:



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Step 2:



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2-(2,4-dihydroxyphenyl)-4,6-bis(aryl)-
1,3,5-triazines

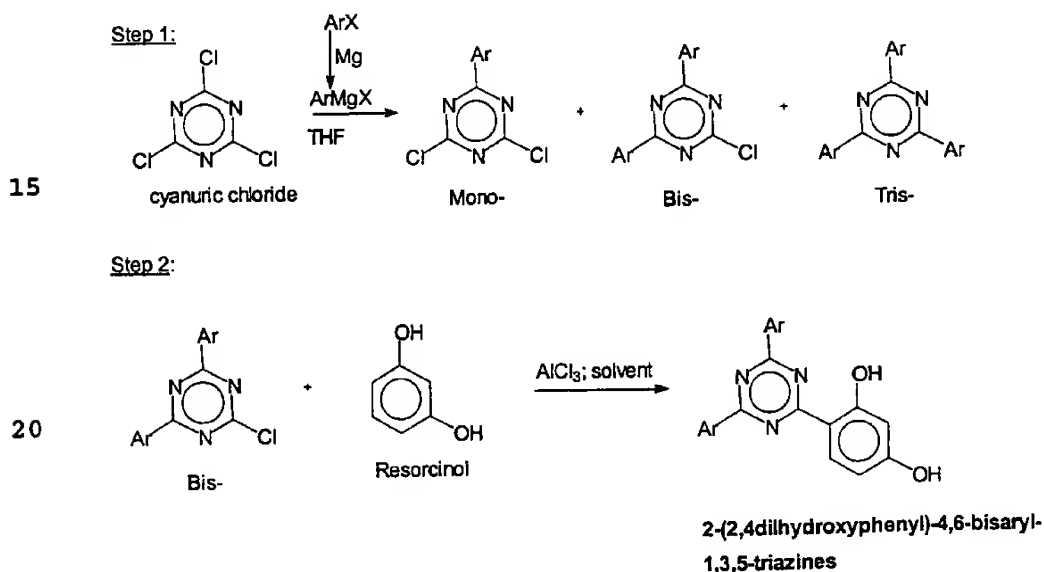
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In another approach, shown below, cyanuric chloride is reacted with an aryl magnesium halide to prepare a monochloro bisaryl triazine in the first step. The substituted triazine intermediate is isolated and subsequently reacted with resorcinol to produce a 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazine. It has been reported that this approach is not selective for the monochloro-bisaryl triazine, for example, Brunetti, page 1575. However, modifications with

better results have been reported, as in U.S. patent 5,438,138. While this approach is generally applicable to many aromatic species, it has the disadvantages of being unsuitable for industrial scale production due to the use of a highly reactive Grignard reagent, and uneconomical due to the special precautions associated with the use of Grignard reagents, and the cost of the raw materials used in these compounds.

SCHEME 2

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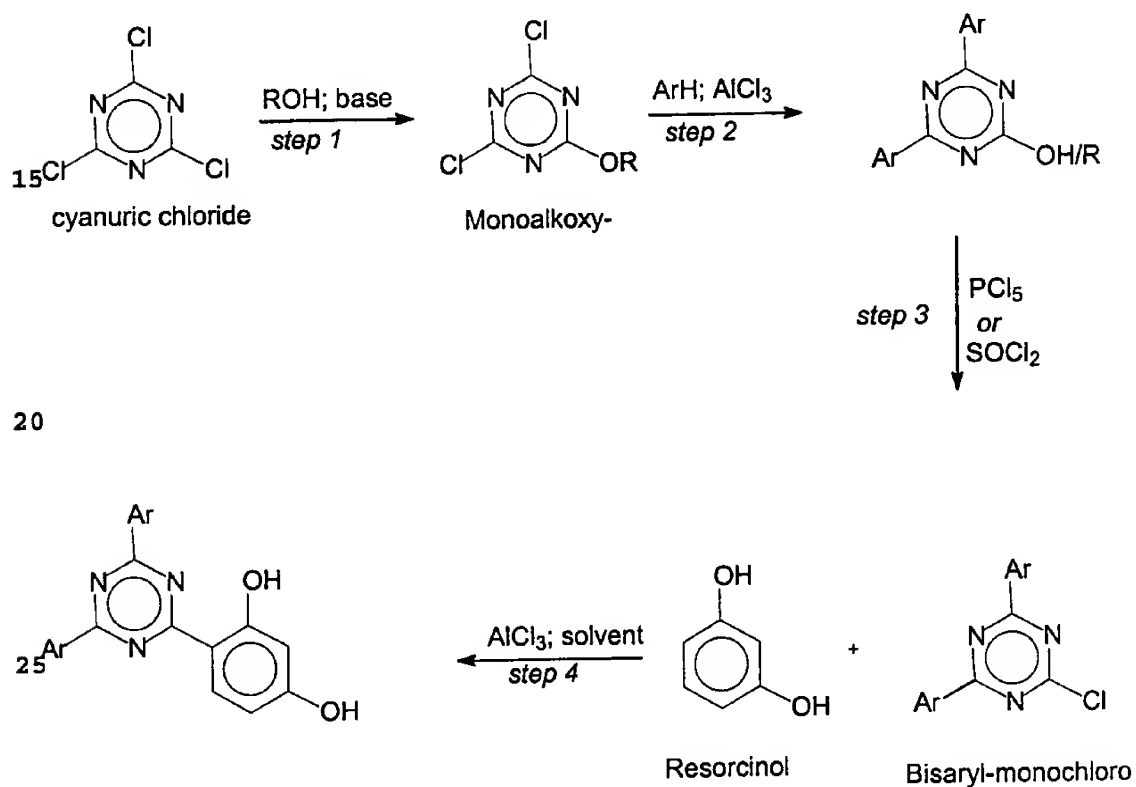
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Alternative approaches have been developed to address the selectivity problem. In one approach, shown below, cyanuric chloride is first reacted with one equivalent of an alcohol to produce, with high selectivity, a monoalkoxy-bischlorotriazine. This substituted triazine is then reacted in a second step with aromatics in the presence of aluminum chloride to prepare monoalkoxy/hydroxy-bisaryltriazines.

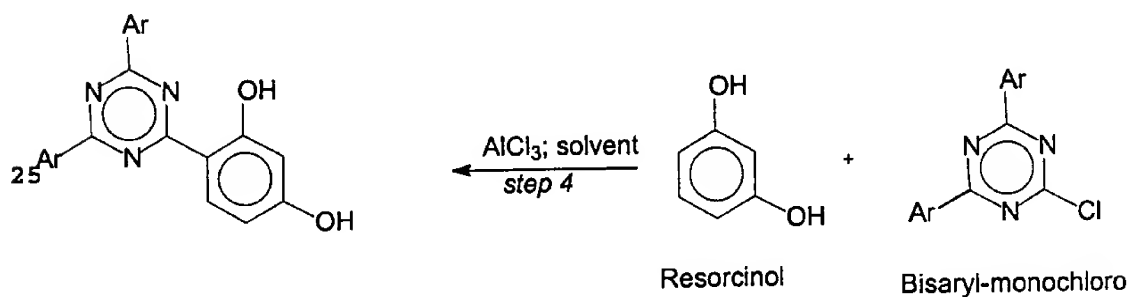
These intermediates are then converted to monochloro-bisaryltriazines by reaction with thionyl chloride or phosphorus pentachloride. The monochloro-bisaryltriazines are finally reacted with resorcinol in a fourth step to prepare the desired 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazine. This approach can be applied generally to aromatic species, and the desired product is formed with selectivity, but the addition of several steps in the synthesis makes this process economically unattractive.

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SCHEME 3



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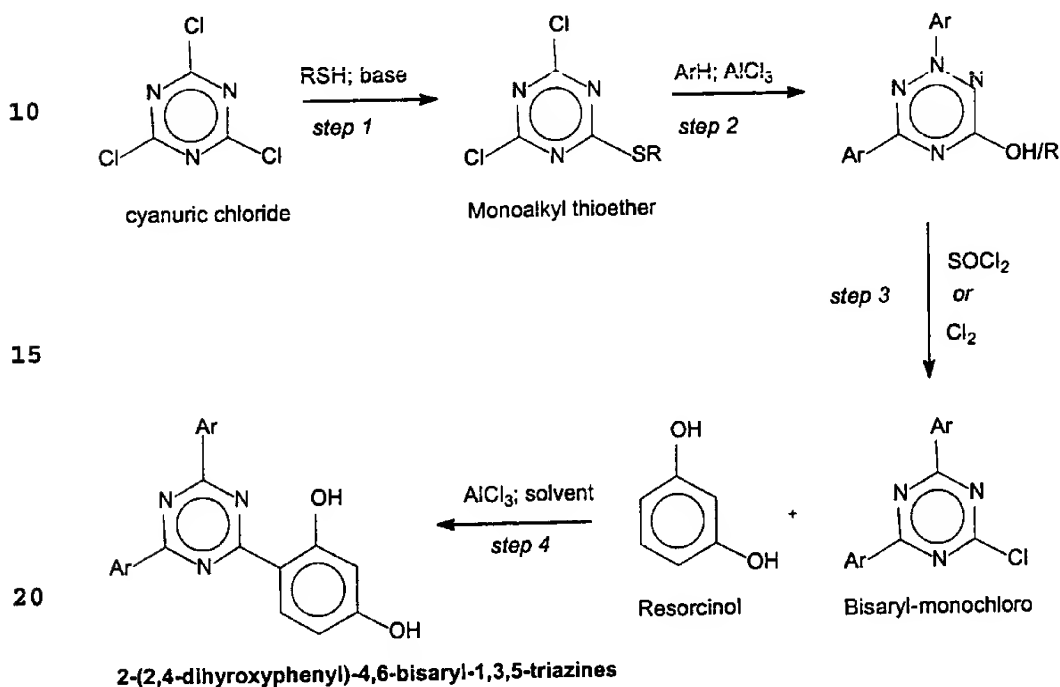


2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazines

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A similar approach is described in US5106972 and US5084570, and is shown below. Cyanuric chloride is first reacted with one equivalent of alkanethiol instead of alcohol. The remaining steps are the same as those described in the previous example. As before, the disadvantage of this approach lies in the additional steps of the synthesis.

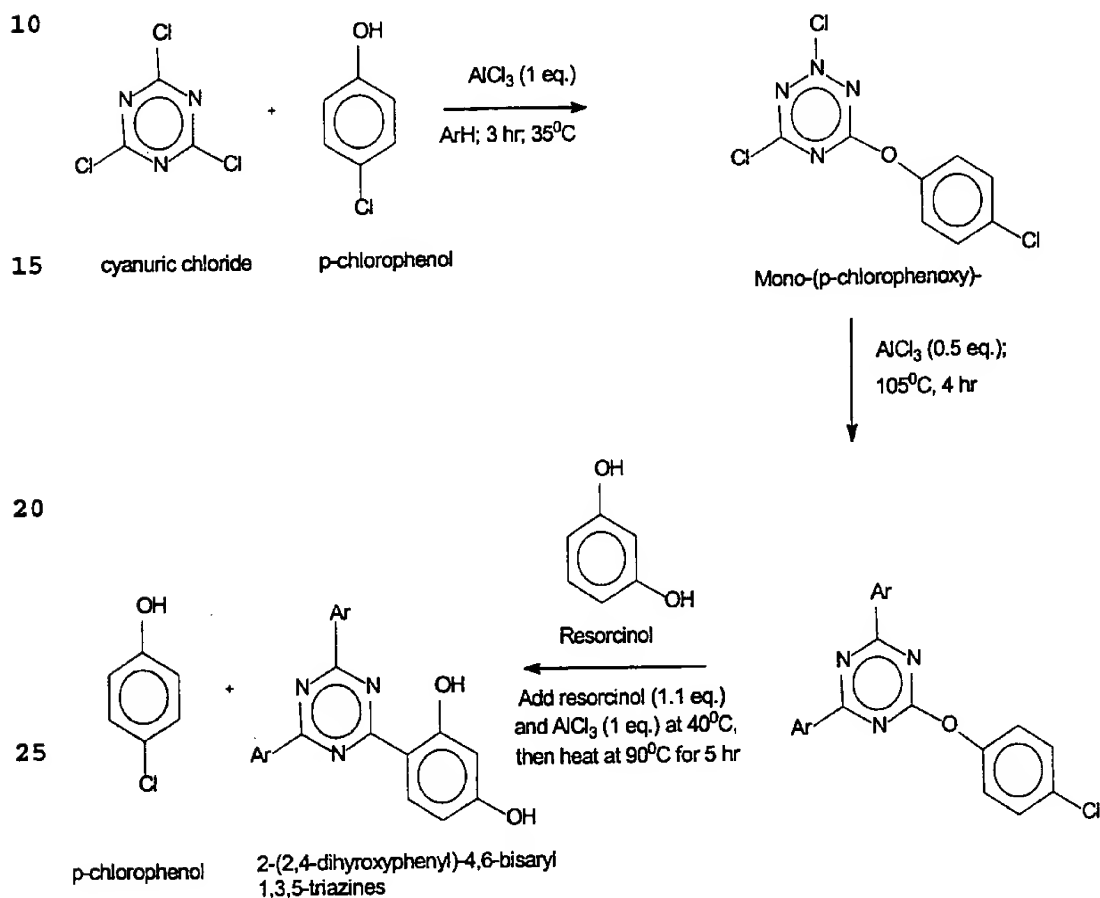
SCHEME 4



25 A modification of this approach is disclosed in Japanese patent application 09-059,263. In this process, cyanuric chloride is first reacted with one equivalent of a substituted phenol, such as para-chlorophenol, in the presence of aluminum chloride to produce the oxygen-linked mono-phenoxy derivative of cyanuric chloride. This intermediate is subsequently reacted with an aromatic, such as meta-xylene, and aluminum chloride to prepare 2-monophenoxy-4,6-bisaryl-1,3,5-triazine, which is subsequently

reacted with resorcinol and aluminum chloride in a third step to produce a 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-triazine. This one-pot, three-step process claims an improved yield of the desired product. However, this method has the disadvantage of the need to use para chlorophenol, a toxic chemical, and the need to remove it from the desired product.

SCHEME 5



A further approach to the production of 2-chloro-4,6-bisaryl-1,3,5-triazines is disclosed in European patent

application 0,497,734. This process involves reacting
benzamidine hydrochloride with a chloroformate and dimerizing
the product. The resultant 2-hydroxy-4,6-bisaryl-1,3,5-
triazine is converted to 2-chloro-4,6-bisaryl-1,3,5-triazine
5 by treatment with thionyl chloride, and finally reaction with
resorcinol to produce the 2-(2,4-dihydroxyphenyl)-4,6-
bisaryl-1,3,5-triazine. This method also has the
disadvantage of using para-chlorophenol, a toxic chemical.
Further the multi-step synthesis renders the process
uneconomical for industrial use.

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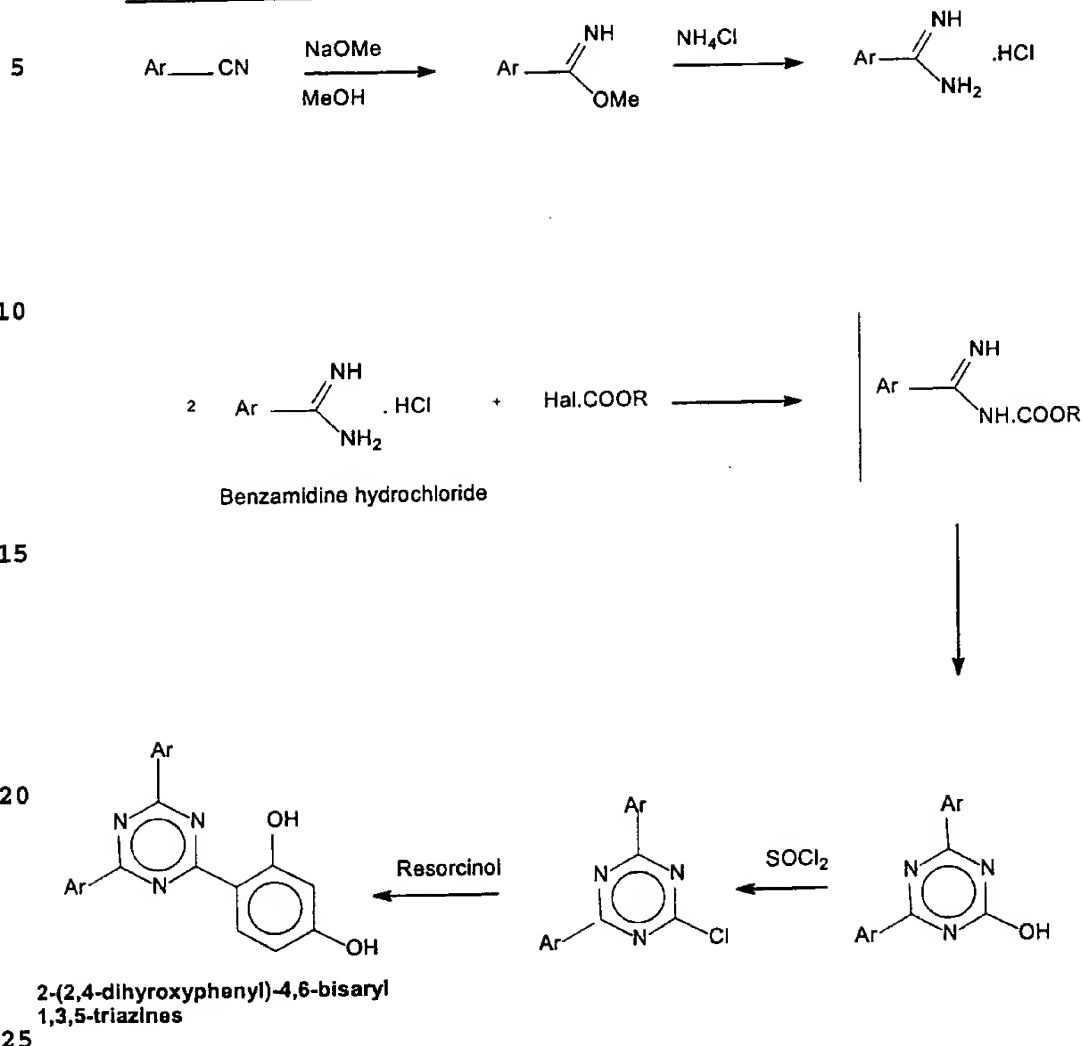
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SCHEME 6

Synthesis of Benzamidines:

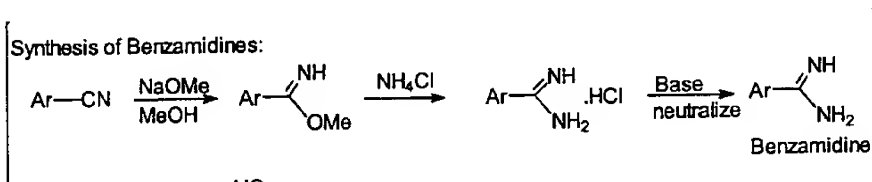
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In addition to the approaches described above, other approaches exist which utilize benzonitriles or benzamidines as the starting material. The use of 2,4-dihydroxybenzaldehyde, phenyl (or alkyl) 2,4-dihydroxybenzoates and 2-aryl-1,3-benzoxazine-4-ones is shown below, and is disclosed in, for example, U.S. patents 5,705,643 and 5,478,935 and PCT application WO96/28431. These approaches have the disadvantages of the starting materials being expensive, and the possible need for additional synthetic steps in the preparation.

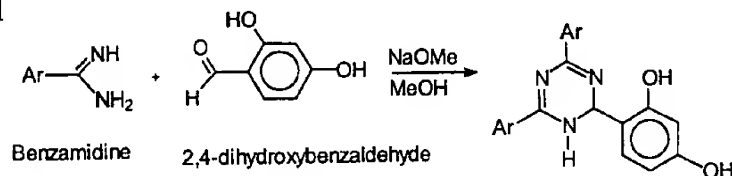
SCHEME 7

Based on Benzamidine reactions with 2,4-dihydroxybenzaldehyde:

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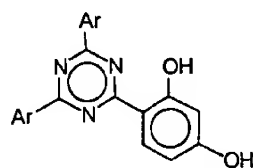


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2-(2,4-dihydroxy)-4,6-bisaryl-1,3,5-triazines
sodium dithionite
or
sodium bisulfite

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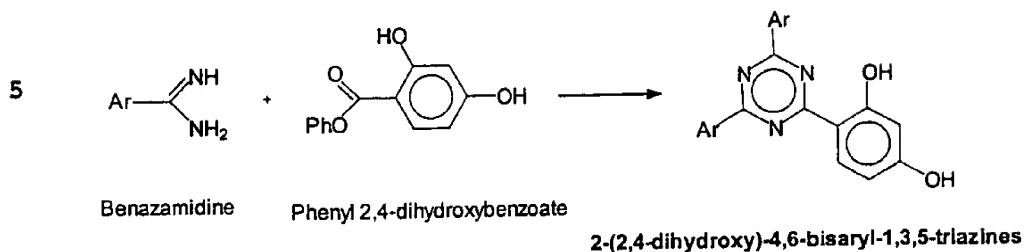


2-(2,4-dihydroxy)-4,6-bisaryl-1,3,5-triazines

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SCHEME 8

Based on Benzamidine reactions with Phenyl 2,4-dihydroxybenzoate:

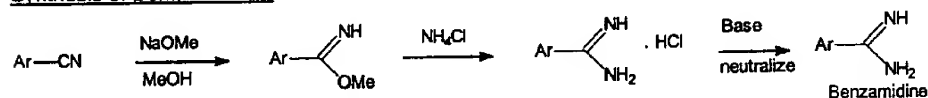


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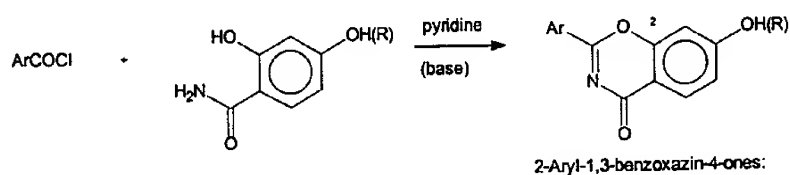
SCHEME 9

Based on Benzamidine reactions with substituted 2-aryl-1,3-benzoxazin-4-ones:

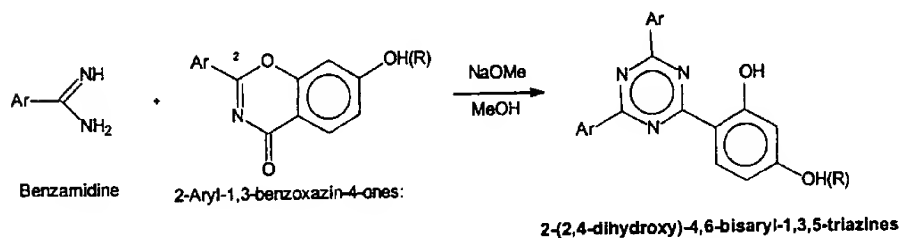
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Synthesis of Benzamidines:Synthesis of 2-aryl-1,3-benzoxazin-4-ones:

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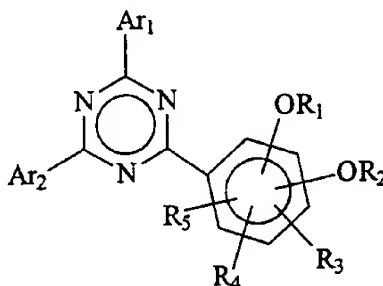
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It can be seen that a need exists for a novel method of production of 2-(2,4-dihydroxyphenyl)-4,6-bisaryl-1,3,5-

triazines which is highly selective, economical, having minimal synthetic steps and need for isolation of the intermediate, and demonstrates improved safety to the chemist and to the environment. It is the object of this invention to provide such a novel method of production.

SUMMARY OF THE INVENTION

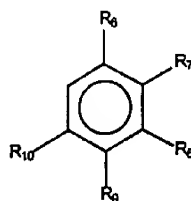
The invention provides a process for preparing compositions containing at least one triazine compound. In particular, the present invention relates to a novel process for the production of a composition comprising at least one triazine compound of Formula A:



Formula A

wherein R_1 , R_2 , R_3 , R_4 and R_5 are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, OCOR, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon

atoms, or aracyl of 6 to 24 carbon atoms, optionally with either of R_3 and R_4 , or R_4 and R_5 , taken together being a part of a saturated or unsaturated fused carbocyclic ring optionally containing O, N or S atoms in the ring, and Y is a direct bond, O, NR'' , or SR'' , wherein R'' is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms or aracyl of 6 to 24 carbon atoms; and Ar_1 and Ar_2 are the same or different, and each independently is a radical of a compound of Formula B:

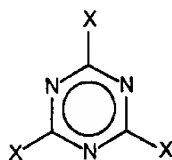


Formula B

wherein R_6 , R_7 , R_8 , R_9 and R_{10} are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, $OCOR$, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, or aracyl of 6 to 24 carbon atoms, and optionally with either of R_6 and R_7 , taken together, R_7 and R_8 , taken together, R_8 and R_9 , taken together, or R_9 and R_{10} , taken together being a

part of a saturated or unsaturated fused carbocyclic ring
optionally containing O, N or S atoms in the ring,
which process comprises:

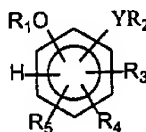
simultaneously reacting in the presence of a catalyst,
5 sufficient amounts of a compound of Formula C:



Formula C

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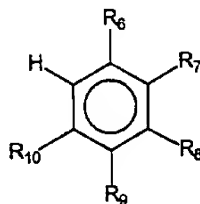
wherein X is a halogen,
a compound of Formula D:



Formula D

15

wherein Y, R₁, R₂, R₃, R₄ and R₅ are as described above,
20 and a compound of Formula E:

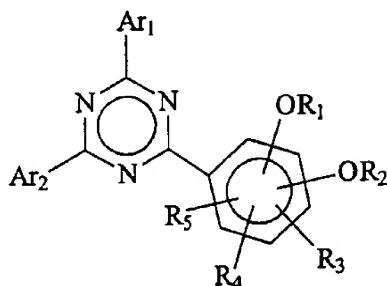


Formula E

25

wherein R₆, R₇, R₈, R₉ and R₁₀ are as described above,
at a suitable temperature and pressure, and for a time
30 sufficient to produce a reaction mixture comprising the
composition.

The present invention relates to a process for the production of a composition comprising at least one triazine compound of Formula A:

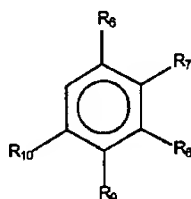


10 Formula A

wherein R_1 , R_2 , R_3 , R_4 and R_5 are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, $OCOR$, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, or aracyl of 6 to 24 carbon atoms, optionally with either of R_3 and R_4 , or R_4 and R_5 , taken together being a part of a saturated or unsaturated fused carbocyclic ring optionally containing O, N or S atoms in the ring, and Y is a direct bond, O, NR'' , or SR'' , wherein R'' is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24

carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms or aracyl of 6 to 24 carbon atoms; and Ar_1 and Ar_2 are the same or different, and each independently is a radical of a compound of Formula B:

5



Formula B

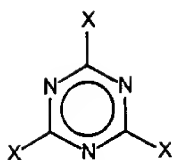
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wherein R_6 , R_7 , R_8 , R_9 , and R_{10} are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, OCOR, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, or aracyl of 6 to 24 carbon atoms, and optionally with either of R_6 and R_7 taken together, R_7 and R_8 taken together, R_8 and R_9 taken together, or R_9 and R_{10} taken together being a part of a saturated or unsaturated fused carbocyclic ring optionally containing O, N or S atoms in the ring, which process comprises:

25

simultaneously reacting in the presence of a catalyst, sufficient amounts of a compound of Formula C:

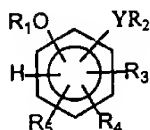
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Formula C

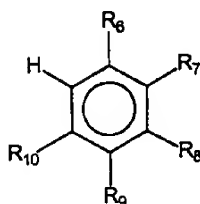
wherein X is a halogen,
a compound of Formula D:



10

Formula D

wherein Y, R₁, R₂, R₃, R₄ and R₅ are as described above,
15 and a compound of Formula E:



20

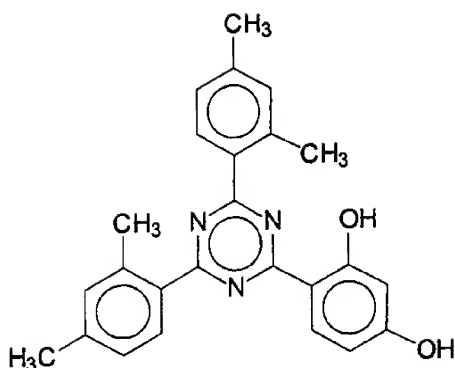
Formula E

wherein R₆, R₇, R₈, R₉ and R₁₀ are as described above,
at a suitable temperature and pressure, and for a time
25 sufficient to produce a reaction mixture comprising the
composition.

This result is unexpected, since theoretically, a
statistical distribution of several products would be
expected to be produced from such a simultaneous reaction.

30 A preferred embodiment of the present invention is a
process for the preparation of 2-(2,4-dihydroxyphenyl)-4,6-
bis(2,4-dimethylphenyl)-1,3,5-triazine,

5



10 which comprises simultaneously reacting in the presence of a catalyst, sufficient amounts of a cyanuric halide, preferably cyanuric chloride; meta-xylene and resorcinol, at a suitable temperature and pressure, and for a time sufficient to produce a reaction mixture comprising the composition.

15 The formation of the mono-resorcinol containing triazine product as the major product, with the bis-resorcinol containing triazine product formed in small amounts is contrary to expectation.

The process of the present invention is a one-pot, one-
20 step process which avoids the need to sustain the reaction mixture at different temperatures for long periods. No significant exotherm is produced in the reaction, despite the fact that all reactants are introduced simultaneously. The fact that no significant exotherm is observed is in contrast to the prior art, which describes uncontrolled exothermic
25 reaction when cyanuric chloride, meta-xylene and aluminum chloride are simultaneously introduced. Thus the process of the present invention discloses a simultaneous reaction of cyanuric chloride with aromatic species and resorcinol, which can be carried out at a relatively low temperature, with no
30 associated safety risks.

Suitable solvents for use in the process of the present invention are aliphatic hydrocarbons, halogenated aliphatic

and aromatic compounds, aliphatic and aromatic nitro compounds and carbon disulfide. Preferred solvents are halogenated solvents such as chlorobenzene, dichlorobenzene and 1,1,2,2-tetrachloroethane.

5 The catalyst used in the process of the present invention is a Lewis acid catalyst. Preferred catalysts are aluminum trihalides. The most preferred catalyst is aluminum chloride.

10 The process of the present invention may be carried out by combining the reactants in the reactor and bringing about the reaction. The reaction takes place at a temperature of between about 0°C to about 120°C. A preferred temperature range is between about 0°C to about 90°C. The most preferred temperature range is between about 10°C to about 60°C.

15 The amount of catalyst used is between about 1.5 to about 4 equivalents based upon the amount of the compound of Formula C. More preferably the amount of catalyst used is between about 2 to about 3.5 equivalents based upon the amount of the compound of Formula C. Most preferably the amount of catalyst used is between about 2.25 to 2.75
20 equivalents based upon the amount of the compound of Formula C.

 The amount of compound of Formula B used is between about 1.9 to 2.5 equivalents based upon the amount of the compound of Formula C.

25 The amount of compound of Formula D used is between about 0.5 to 1.5 equivalents based upon the amount of the compound of Formula C. More preferably the amount of compound of Formula D used is between about 0.9 to 1.1 equivalents based upon the amount of the compound of Formula C.

30 The compounds used in the process of the present invention can be added to the reaction vessel in any

sequence. The preferred time for the reaction is between about 2 to about 24 hours.

Uses of Triazines

5 The triazines of the present invention are particularly useful as ultraviolet light absorber agents for stabilizing a wide variety of materials including, for example, various polymers (both crosslinked and thermoplastic), photographic materials and dye solutions for textile materials, as well as in ultraviolet light screening
10 agents (such as sunscreens). The triazines of the present invention can be incorporated into such material in any one of a variety of conventional manners, including for example, physical mixing or blending, optionally, with chemical bonding to the material (typically to a polymer), as a
15 component in a light stabilizing composition such as a coating or solution, or as a component in a UV screening composition such as a sunscreen composition.

 The triazines of the present invention can be employed to stabilize materials which are subject to degradation by ultraviolet radiation by incorporating the
20 presently claimed compounds into polymeric materials, either chemically or physically. Non-limiting examples of polymeric materials that may be so stabilized are polyolefins, polyesters, polyethers, polyketones, polyamides, natural and synthetic rubbers, polyurethanes, polystyrenes, high-impact
25 polystyrenes, polyacrylates, polymethacrylates, polyacetals, polyacrylonitriles, polybutadienes, polystyrenes, ABS, SAN (styrene acrylonitrile), ASA (acrylate styrene acrylonitrile), cellulosic acetate butyrate, cellulosic polymers, polyimides, polyamideimides, polyetherimides,
30 polyphenylsulfide, PPO, polysulfones, polyethersulfones, polyvinylchlorides, polycarbonates, polyketones, aliphatic polyketones, thermoplastic TPU's, aminoresin crosslinked

polyacrylates and polyesters, polyisocyanate crosslinked
polyesters and polyacrylates, phenol/formaldehyde,
urea/formaldehyde and melamine/formaldehyde resins, drying
and non-drying alkyd resins, alkyd resins, polyester resins,
5 acrylate resins cross-linked with melamine resins, urea
resins, isocyanates, isocyanurates, carbamates, and epoxy
resins, cross-linked epoxy resins derived from aliphatic,
cycloaliphatic, heterocyclic and aromatic glycidyl compounds,
which are cross-linked with anhydrides or amines,
polysiloxanes, Michael addition polymers, amines, blocked
10 amines with activated unsaturated and methylene compounds,
ketimines with activated unsaturated and methylene compounds,
polyketimines in combination with unsaturated acrylic
polyacetoacetate resins, polyketimines in combination with
unsaturated acrylic resins, radiation curable compositions,
15 epoxymelamine resins, organic dyes, cosmetic products,
cellulose-based paper formulations, photographic film paper,
ink, and blends thereof.

Further non-limiting examples of specific polymers
which may be stabilized include:

- 20 1. Homo- and copolymers of monoolefins and diolefins
including but not limited to ethylene, propylene,
isobutylene, butene, methylpentene, hexene, heptene,
octene, isoprene, butadiene, hexadiene,
dicyclopentadiene, ethylidene and cycloolefins such as
cyclopentene and norbornene; for example, polyethylenes
25 (which optionally can be crosslinked) such as high
density polyethylene (HDPE), high density and high
molecular weight polyethylene (HDPE-HMW), high density
and ultrahigh molecular weight polyethylene (HDPE-UHMW),
medium density polyethylene (MDPE), low density
30 polyethylene (LDPE), linear low density polyethylene
(LLDPE) and branched low density polyethylene (BLDPE).

2. Copolymers of one or more monoolefins and/or diolefins with carbon monoxide and/or with other vinyl monomers, including limited acrylic and methacrylic acid, acrylates and methacrylates, acrylamides, acrylonitriles, styrenes, vinyl acetate (such as ethylene/vinyl acetate copolymers), vinyl halides, vinylidene halides, maleic anhydride and allyl monomers such as allyl alcohol, allyl amine ally glycidyl ether and derivatives thereof.
3. Hydrocarbon resins (such as C₅-C₉) including hydrogenated modifications thereof and mixtures of polyalkylenes and starch.
4. Homo- and copolymers of styrenes such as styrene, p-methylstyrene and α -methylstyrene.
5. Copolymers of one or more styrenes with other vinyl monomers such as olefins and diolefins (e.g., ethylene, isoprene and/or butadiene), acrylic and methacrylic acid, acrylates and methacrylates, acrylamides, acrylonitriles, vinyl acetate (such as ethylene/vinyl acetate copolymers), vinyl halides, vinylidene halides, maleic anhydride and allyl compounds such as allyl alcohol, allyl amine allyl glycidyl ether and derivatives thereof.
6. Graft copolymers of styrenes on polybutadienes, polybutadiene/styrene copolymers and polybutadiene/acrylonitrile copolymers; styrene (or α -methylstyrene) and acrylonitrile (or methacrylonitrile) on polybutadiene; styrene and maleic anhydride on polybutadiene; styrene, acrylonitrile and maleic anhydride or maleimide on polybutadiene; styrene and acrylonitrile on ethylene/propylene/diene copolymers; styrene and acrylonitrile on polyalkyl acrylates or methacrylates; and styrene and acrylonitrile on acrylate/butadiene copolymers.

7. Halogen-containing polymers such as polychloroprene; chlorinated rubbers; chlorinated and brominated isobutylene/isoprene copolymers; chlorinated or sulfochlorinated polyethylene; copolymers of ethylene and chlorinated ethylene; epichlorohydrin polymers and copolymers; and polymers and copolymers of halogen-containing vinyl compounds such as vinyl chloride, vinylidene chloride, vinyl fluoride and/or vinylidene fluoride and other vinyl monomers.
8. Homo- and copolymers derived from α,β -unsaturated acids and derivatives thereof such as acrylic acid, methacrylic acid, acrylates, methacrylates, acrylamides and acrylonitriles.
9. Copolymers of the monomers mentioned in (8) with other unsaturated monomers such as olefins and diolefins (e.g., butadiene), styrenes, vinyl halides, maleic anhydride and allyl monomer such as allyl alcohol, allyl amine, allyl glycidyl ether and derivatives thereof.
10. Homo- and copolymers derived from unsaturated alcohols and amines or the acyl derivatives or acetals thereof, such as vinyl alcohol, vinyl acetate, vinyl stearate, vinyl benzoate, vinyl maleate, vinyl butyral, allyl alcohol, allyl amine, allyl glycidyl ether, allyl phthalate and allyl melamine; as well as copolymers of such monomers with other ethylenically unsaturated monomers mentioned above.
- 25 For the preceding polymer groups 1-10, the present invention includes these polymers as prepared by metallocene catalysts.
11. Homo- and copolymers of cyclic ethers such as alkylene glycols and alkylene oxides, as well as copolymers with bisglycidyl ethers.
- 30 12. Polyacetals such as polyoxymethylene and those polyoxymethylenes which contain ethylene oxide as a

- comonomer; and polyoxymethylenes modified with thermoplastic polyurethanes, acrylates and/or MBS.
13. Polyphenylene oxides and sulfides.
14. Polyurethanes derived from hydroxy-functional components such as polyhydric alcohols, polyethers, polyesters, 5 polyacrylics and/or polybutadienes on the one hand, and aliphatic and/or aromatic isocyanates on the other, as well as precursors thereof.
15. Polyamides and copolyamides derived from diamines, dicarboxylic acids and/or aminocarboxylic acids or the 10 corresponding lactams, such as polyamide 4, polyamide 6, polyamide 6/6, polyamide 6/10, polyamide 6/9, polyamide 6/12, polyamide 4/6, polyamide 12/12, polyamide 11 and polyamide 12; aromatic polyamides starting from m-xylene diamine and adipic acid; polyamides prepared from 15 hexamethylene diamine and isophthalic and/or terephthalic acid and with or without an elastomer as a modifier, for example, poly-2,4,4-trimethylhexamethylene terephthalamide or poly-m-phenylene isophthalamide; block copolymers of the aforementioned polyamides with 20 polyolefins, olefin copolymer, ionomers, chemically bonded or grafted elastomers, or polyethers such as polyethylene glycol, polypropylene glycol or polytetramethylene glycol; and polyamides condensed during processing (RIM polyamide systems).
16. Polyureas, polyimides, polyamide-imides, 25 polyetherimides, polyesterimides, polyhydantoins and polybenzimidazoles.
17. Polyesters derived from dicarboxylic acids, diols and/or hydroxycarboxylic acids or the corresponding lactones, such as polyethylene terephthalate, polybutylene 30 terephthalate, poly-1,4-dimethylcyclohexane terephthalate and polyhydroxybenzoates, as well as block copolyether esters derived from hydroxyl-terminated

- ethers; PETG; PEN; PTT; and also polyesters modified with polycarbonate or MBS.
18. Polycarbonates and polyester carbonates.
 19. Polysulfones, polyether sulfones and polyether ketones.
 - 5 20. Crosslinked polymers derived from aldehydes condensation resins such as phenol/formaldehyde resins, urea/formaldehyde resins and melamine/formaldehyde resins.
 21. Drying and non-drying alkyd resins.
 - 10 22. Unsaturated polyester resins derived from copolyesters of saturated and unsaturated dicarboxylic acids with polyhydric alcohols and vinyl compounds as crosslinking agents and also halogen-containing modifications thereof.
 - 15 23. Crosslinkable acrylic resins derived from substituted acrylates such as epoxy acrylates, hydroxy acrylates, isocyanato acrylates, urethane acrylates or polyester acrylates.
 - 20 24. Alkyd resins, polyester resins and acrylate resins crosslinked with melamine resins, urea resins, isocyanates, isocyanurates, carbamates or epoxy resins.
 - 25 25. Crosslinked epoxy resins derived from aliphatic, cycloaliphatic, heterocyclic and/or aromatic glycidyl compounds such as bisphenol A and bisphenol F, which are crosslinked with customary hardeners such as anhydrides or amines.
 - 30 26. Natural polymers such as cellulose, rubber, gelatin and chemically modified homologous derivatives thereof, including cellulose acetates, cellulose propionates and cellulose butyrates, or the cellulose ethers such as methyl cellulose, as well as rosins and their derivatives.
 27. Polysiloxanes.

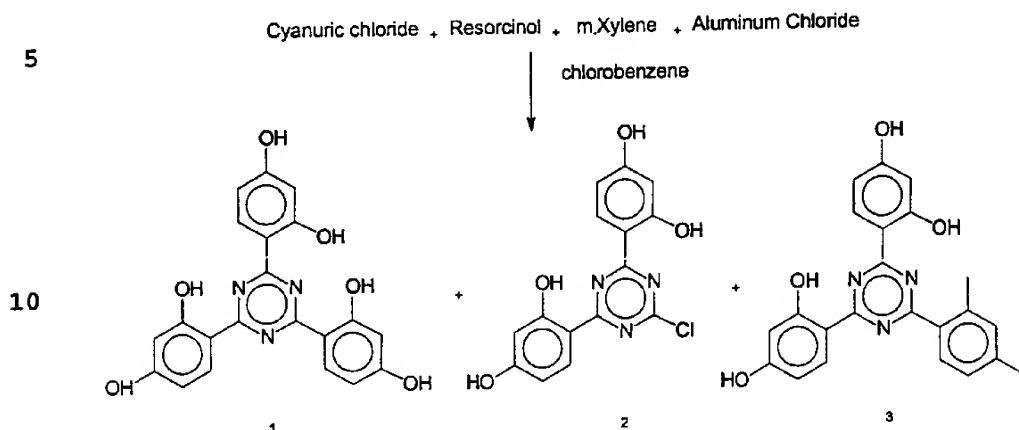
28. Michael addition polymers of amines or blocked amines (e.g., ketimines) with activated unsaturated and/or methylene compounds such as acrylates and methacrylates, maleates and acetoacetates.
- 5 29. Mixtures or blends of any of the above, such as PP/EPDM, polyamide/EPDM or ABS, PVC/EVA, PVC/ABS, PVC/MBS, PC/ABS, PBTP/ABS, PC/ASA, PC/PBT, PVC/CPE, PVC/acrylate, POM/thermoplastic PUR, PC/thermoplastic polyurethane, POM/acrylate, POM/MBS, PPO/HIPS, PPO/PA6.6 and
- 10 copolymers, PA/HDPE, PP/HDPE, PP/LDPE, LDPE/HDPE, LDPE/EVA, LDPE/EAA, PA/PP, PA/PPO, PBT/PC/ABS, PBT/PET/PC and the like.
30. Polyketimines in combination with unsaturated acrylic polyacetoacetate resins or with unsaturated acrylic resins including urethane acrylates, polyether
- 15 acrylates, vinyl or acryl copolymers with pendant unsaturated groups and acrylated melamines.
31. Radiation curable compositions containing ethylenically unsaturated monomers or oligomers and a polyunsaturated aliphatic oligomer.
- 20 32. Epoxymelamine resins such as light-stable epoxy resins cross-linked by an epoxy functional coetherified high solids melamine resin.
- Other materials which can be stabilized include, for example:
33. Naturally occurring and synthetic organic materials which may be mixtures of compounds, including mineral
- 25 oils, animal and vegetable fats, oils and waxes, or oils, fats or waxes based on synthetic esters (e.g., phthalates, adipates, phosphates or trimellitates) and also mixtures of synthetic esters with mineral oils in any ratio.
- 30 34. Aqueous emulsions of natural or synthetic rubber such as natural latex or lattices of carboxylated styrene/butadiene copolymers.

35. Organic dyes such as azo dyes (diazo, triazo and polyazo), anthraquinones, benzodifuranones, polycyclic aromatic carbonyl dyes, indigoid dyes, polymethines, styryl dyes, di- and triaryl carbonium dyes, phthalocyanines, quinophthalones, sulfur dyes, nitro and nitroso dyes, stilbene dyes, formazan dyes, quinacridones, carbazoles and perylene tetracarboxylic diimides.
36. Cosmetic products, such as skin lotions, collagen creams, sunscreen, facial make-up, etc., comprising synthetic materials such as antioxidants, preservatives, lipids, solvents, surfactants, colorants, antiperspirants, skin conditioners, moisturizers etc.; as well as natural products such as collagen, proteins, mink oil, olive oil, coconut oil, carnauba wax, beeswax, lanolin, cocoa butter, xanthan gum, aloe, etc.
37. Cellulose-based paper formulations for use, e.g., in newsprint, cardboard, posters, packaging, labels, stationery, book and magazine paper, bond typing paper, multi-purpose and office paper, computer paper, xerographic paper, laser and ink-jet printer paper, offset paper, currency paper, etc.
38. Photographic film paper.
39. Ink.

EXAMPLES

The invention will now be illustrated by the following examples. The examples are not intended to be limiting of the scope of the present invention. In conjunction with the general and detailed descriptions above, the examples provide further understanding of the present invention.

Comparative Example 1: Reaction of cyanuric chloride, m-xylene, resorcinol, and aluminum trichloride. Use of 1.0 eq. aluminum trichloride.



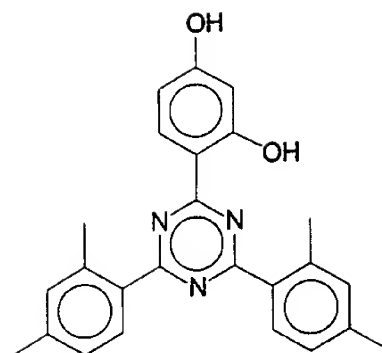
15 A mixture of 1.84 g cyanuric chloride (10 mmol), 2.12 g of m-xylene (2 eq.), and 1.10 g of resorcinol (1 eq.) in 20 mL chlorobenzene under a nitrogen atmosphere was cooled to 2°C. Aluminum trichloride (2.12 g, 1 eq.) was added over 2 mm. The mixture was then warmed to 35°C with stirring.

20 After 22 hr., a sample was taken and quenched with ice and dilute aq. HCl. The resulting precipitate was filtered, washed with water, dissolved in tetrahydrofuran and analyzed by HPLC. HPLC analysis (area % at 290 nm) showed mainly tris- and bis-resorcinol containing triazine products 2,4,6-

25 tris-(2,4-dihydroxyphenyl)-s-triazine (1) and 2-chloro-4,6-bis-(2,4-dihydroxyphenyl)-s-triazine (2) with no m-xylyl substitution. The ratio of 1 to 2 was 21:78. Unreacted m-xylene was also present. The only triazine product containing xylene observed was bisresorcinol-triazine based 2,4-bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-s-

30 triazine 3. The monoresorcinol-triazine based product, 2-(2,4-dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)-s-triazine 4 was not formed.

5



4

10

The formation of only trisresorcinol-triazine and bisresorcinol-triazine based products is in agreement with the prior art cited before (Y. Horikoshi, et al, *Nippon Kagaku Kaishi* (3), 530- 5, 1974; CA 81:152177 and U.S. 3,270,016 (Ex. 6)).

Example 1: 2-(2,4-Dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)s-triazine (4). Use of 2.5 eq aluminum trichloride.

20 To a stirring mixture of 1.84 g of cyanuric chloride, 1.1 gm of resorcinol, 2.5 mL of m-xylene and 25 mL of chlorobenzene was added 3.35 g of aluminum chloride (2.5 eq. based on cyanuric chloride) at 5°C. The reaction mixture was stirred at 5°C for 2h, then at 15°C for 4 hr and finally at room temperature for 24 hr. The reaction mixture was
25 analyzed by TLC and HPLC. The HPLC analysis confirmed the formation of 2-(2,4-dihydroxyphenyl)-4,6-(2,4-dimethylphenyl)-1,3,5-triazine (4) and 2,4,6-tris(2,4-dimethylphenyl)-1,3,5-triazine as the only two major products. The bisresorcinol based product, 2,4-bis(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-1,3,5-triazine (3),
30 was formed only as a minor component and the ratio of 4:3 was 97:3. The 2-chloro-4,6-bis(2,4-dihydroxyphenyl)s-triazine

(2) was only 0.36% and 2,4,6-tris-(2,4-dihydroxyphenyl)-s-triazine (1) was 0.5%. The experiment demonstrated the preferential formation of monoresorcinol based product 4 by reacting cyanuric chloride, resorcinol, m-xylene and aluminum chloride simultaneously with higher charge of aluminum chloride.

Example 2: 2-(2,4-Dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)-s-triazine (4). Use of 2.25 eq aluminum trichloride.

A mixture of 10 g cyanuric chloride (0.0542 mol), 11.51 g of m-xylene (2 eq.), and 5.97 g of resorcinol (1 eq.) in 100 mL chlorobenzene under a nitrogen atmosphere was cooled to 2°C under a nitrogen atmosphere. Aluminum trichloride (16.26 g, 2.25 eq.) was added over 25 min. such that the temperature was maintained below 5°C. The mixture was then warmed to 25°C with stirring, and the progress of the reaction was monitored by HPLC (area % at 290 nm). After 24 hr. at 25°C, HPLC analysis showed 37.6% of 2-(2,4-dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)-s-triazine (4) and only 1.0% of 1, 4.4% of 2, and 5.1% of 3. Additional m-xylene (2 eq.) and aluminum trichloride (0.25 eq.) were added, and the mixture was heated to 32 - 35°C for 20 hr. HPLC analysis indicated that the yield of 1 was increased to 45.3% and there was only 1.9% 2,4,6-tris-(2,4-dihydroxyphenyl)-5-triazine and 5.6% 2,4-bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-5-triazine.

Example 3: 2-(2,4-Dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-s-triazine (4). Use of 2.25 eq aluminum trichloride; Initial reaction temperature of 35°C.

A mixture of 10 g cyanuric chloride (0.0542 mol),
5 11.51 g of m-xylene (2 eq.), and 5.97 g of resorcinol (1 eq.)
in 100 mL chlorobenzene under a nitrogen atmosphere was
cooled to 2°C. Aluminum trichloride (16.26 g, 2.25 eq.) was
added over 25 min. such that the temperature was maintained
below 5°C. The mixture was then warmed to 35°C with
10 stirring, and the progress of the reaction was monitored by
HPLC (area % at 290 nm). After 23 hr. at 35°C HPLC analysis
showed 47.4% 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-
dimethylphenyl)-s-triazine (4) and only 7.6% of 2,4-bis-(2,4-
dihydroxyphenyl)-6-(2,4-dimethyl-s-triazine (3), with no
unreacted cyanuric chloride. Additional m-xylene (28.77 g)
15 and 5.43 g aluminum trichloride (0.75 eq.) were added, and
the mixture was heated to 55 - 60°C for 24 hr. HPLC analysis
indicated that the yield of 1 was increased to 51%.

Example 4: Reaction of cyanuric chloride, m-xylene,
20 resorcinol, and aluminum trichloride. Use of 2.0 eq aluminum
trichloride.

A mixture of 10 g cyanuric chloride (0.0542 mol),
11.51 g of m-xylene (2 eq.), and 5.97 g of resorcinol (1 eq.)
in 100 mL chlorobenzene under a nitrogen atmosphere was
25 cooled to 2°C. Aluminum trichloride (14.45 g, 2.0 eq.) was
added over 30 min. such that the temperature was maintained
below 5°C. The mixture was then warmed to 25°C with
stirring, and the progress of the reaction was monitored by
HPLC (area% at 290 nm). Bis-resorcinol products, 2-chloro-
4,6-bis-(2,4-dihydroxyphenyl)-s-triazine (2, 20%) and 2,4-
30 bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-5-triazine
(3, 7%) were formed. The target monoresorcinol product 2-

(2,4-dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)-s-triazine (4) was also formed, although in low yield (20%).

Example 5: 2-(2,4-Dihydroxyphenyl)-4,6-bis-(2,4-dimethylphenyl)-s-triazine (1). Reaction temperature of 45°C.

Example 3 was repeated, except the reaction was run at 45°C instead of 35°C. After only 6 hr., the cyanuric chloride was nearly completely consumed, and HPLC analysis (area % at 290 nm) showed 36.5% 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-s-triazine (4) and only 3.9 area % bis-resorcinol-triazine products: 2-chloro-4,6-bis-(2,4-dihydroxyphenyl)-5-triazine (2,1.4 area %) and 2,4-bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-s-triazine (3, 2.5 area %). After 26 hr. at 45°C, the yield of 1 was increased to 41.8% with 4.8 area % of 2,4-bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-s-triazine (3).

These experiments taken together demonstrate that the yield of 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-s-triazine (4) can be optimized and the yield of bis-resorcinol-s-triazine products can be minimized using the appropriate amount of aluminum chloride and temperature. Any further improvements in yield obtained by optimization of these variables is considered within the scope of this invention

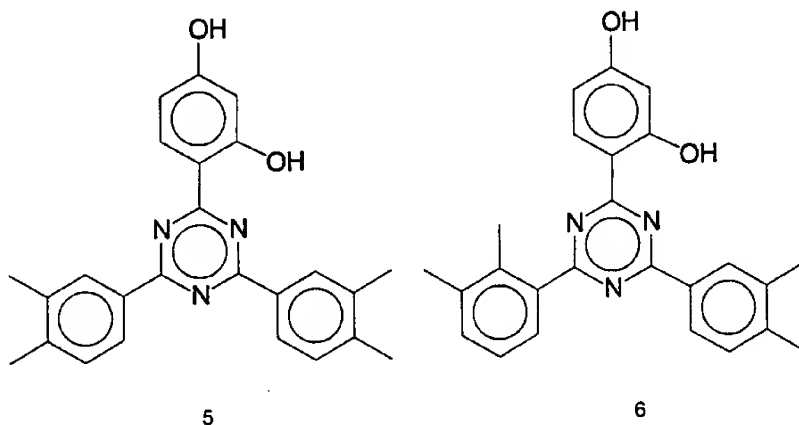
Example 6: 2-(2,4-Dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-s-triazine (1). Use of ortho-dichlorobenzene as the solvent.

The basic procedure of Example 3 was followed, except ortho-dichlorobenzene was used as the solvent in place of chlorobenzene. A mixture of 1.84 g cyanuric chloride (10 mmol), 2.12 g of m-xylene (2 eq.), and 1.10 g of resorcinol (1 eq.) in 20 mL chlorobenzene under a nitrogen atmosphere

was cooled to 4°C. Aluminum trichloride (3.00 g) was added over 20 mm. such that the temperature was maintained below 6°C. The mixture was then warmed to 35°C with stirring, and the progress of the reaction was monitored by HPLC. After 17.5 hr. at 35°C, HPLC analysis (area % at 290 nm) showed 37.1% 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-5-triazine (4) with 9.0% bis-resorcinol-triazine products: 2-chloro-4,6-bis-(2,4-dihydroxyphenyl)-s-triazine (2, 3.0%) and 2,4-bis-(2,4-dihydroxyphenyl)-6-(2,4-dimethylphenyl)-s-triazine (3, 6.0%).

This experiment demonstrates that 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-s-triazine can be prepared and the yield of bis-resorcinol-s-triazine products can be minimized using solvents other than chlorobenzene. The use of solvents other than chlorobenzene for this process is therefore considered within the scope of this invention.

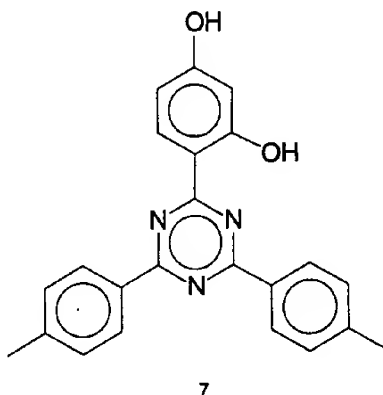
Example 7: 2-(2,4-Dihydroxyphenyl)-4,6-bis(3,4-dimethylphenyl)-5-triazine (5) and 2-(2,4-Dihydroxyphenyl)-4,6-bis(2,3-dimethylphenyl)-s-triazine (6).



The basic procedure of Example 5 was followed, except 2 eq. of ortho-xylene was used as the aromatic reactant in place of

2 eq. of meta-xylene, and chlorobenzene was use as the solvent. The progress of the reaction was monitored by HPLC. After 18 hr. at 35°C, HPLC analysis (area % at 290 nm) showed 35.7% bis-(ortho-xylyl)-mono-resorcinol-s-triazines 34.0% 2-(2,4-dihydroxyphenyl)-4,6-bis(3,4-dimethylphenyl)-s-triazine (5) and 1.7% 2-(2,4-dihydroxyphenyl)-4-(3,4-dimethylphenyl)-6-(2,3-dimethylphenyl)-s-triazine (6); with 3.8% 2-chloro-4,6-bis-(2,4-dihydroxyphenyl)-5-triazine and 3.6% 2,4-bis(2,4-dihydroxyphenyl)-6-(3,4-dimethylphenyl)-s-triazine.

10 **Example 8:** 2-(2,4-Dihydroxyphenyl)-4,6-bis(4-methylphenyl)-5-triazine (7)



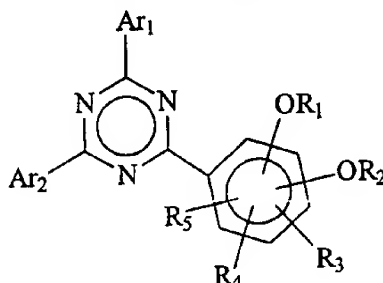
The basic procedure of Example 7 was followed, except 2 eq. of toluene was used as the aromatic reactant in place of 2 eq. of meta-xylene. The progress of the reaction was 25 monitored by HPLC (peak detection at 290 nm). After 23 hr. at 35°C, HPLC analysis showed the formation of 17.3% 2-(2,4-dihydroxyphenyl)-4,6-bis(4-methylphenyl)s-triazine (7).

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THE CLAIMS

What is claimed is:

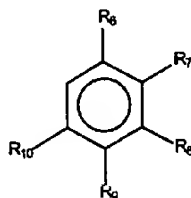
1. A process for preparing a composition comprising at least one triazine compound of Formula A:



Formula A

wherein R_1 , R_2 , R_3 , R_4 and R_5 are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, $OCOR$, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, or aracyl of 6 to 24 carbon atoms, optionally with either of R_3 and R_4 , or R_4 and R_5 , taken together being a part of a saturated or unsaturated fused carbocyclic ring optionally containing O, N or S atoms in the ring, and Y is a direct bond, O, NR'' , or SR'' , wherein R'' is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon

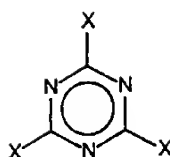
atoms, aryl of 6 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms or aracyl of 6 to 24 carbon atoms; and Ar_1 and Ar_2 are the same or different, and each independently is a radical of a compound of Formula B:



Formula B

wherein R_6 , R_7 , R_8 , R_9 and R_{10} are the same or different and each is hydrogen, halogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, aracyl of 6 to 24 carbon atoms, OR, NRR' , $CONRR'$, $OCOR$, CN, SR, SO_2R , SO_3H , SO_3M , wherein M is an alkali metal, R and R' are the same or different and each is hydrogen, alkyl of 1 to 24 carbon atoms, haloalkyl of 1 to 24 carbon atoms, aryl of 6 to 24 carbon atoms, alkenyl of 2 to 24 carbon atoms, acyl of 1 to 24 carbon atoms, cycloalkyl of 5 to 24 carbon atoms, cycloacyl of 5 to 24 carbon atoms, aralkyl of 7 to 24 carbon atoms, or aracyl of 6 to 24 carbon atoms, and optionally with either of R_6 and R_7 taken together, R_7 and R_8 taken together, R_8 and R_9 taken together, or R_9 and R_{10} taken together being a part of a saturated or unsaturated fused carbocyclic ring optionally containing O, N or S atoms in the ring, which process comprises:

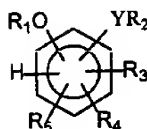
simultaneously reacting in the presence of a catalyst, sufficient amounts of a compound of Formula C:



Formula C

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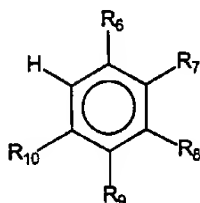
wherein X is a halogen,
a compound of Formula D:



Formula D

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wherein Y, R₁, R₂, R₃, R₄ and R₅ are as described above,
15 and a compound of Formula E:



Formula E

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wherein R₆, R₇, R₈, R₉ and R₁₀ are as described above,
at a suitable temperature and pressure, and for a time
sufficient to produce a reaction mixture comprising the
25 composition.

2. The process of claim 1, wherein Ar₁ and Ar₂ are the
same.

30 3. The process of claim 1, wherein the catalyst is a
Lewis acid and X is chlorine.

4. The process of claim 3, wherein the catalyst is selected from the group consisting of aluminum tribromide, zinc chloride, boron trichloride, titanium tetrachloride, aluminum trichloride, and a mixture thereof.

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5. The process of claim 3, wherein the amount of catalyst is from about 1.5 to about 4 equivalents based upon the amount of the compound of Formula C.

10 6. The process of claim 5, wherein the amount of catalyst is from about 2 to about 3.5 equivalents based upon the amount of the compound of Formula C.

7. The process of claim 6, wherein the amount of catalyst is from about 2.25 to about 2.75 equivalents based
15 upon the amount of the compound of Formula C.

8. The process of claim 1, wherein the amount of the compound of Formula B is from about 1.9 to about 2.5 equivalents based upon the amount of the compound of Formula
20 C.

9. The process of claim 1, wherein the amount of the compound of Formula D is from about 0.5 to about 1.5 equivalents based upon the amount of the compound of Formula
25 C.

10. The process of claim 9, wherein the amount of the compound of Formula D is from about 0.9 to about 1.1 equivalents based upon the amount of the compound of Formula
C.

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11. The process of claim 1, wherein the reaction occurs at a temperature of between 0°C and about 120°C.

12. The process of claim 11, wherein the reaction is conducted at a temperature of between about 0°C and about 90°C.

5 13. The process of claim 11, wherein the reaction is conducted at a temperature of between about 10°C and about 60°C.

10 14. The process of claim 1, wherein the reaction is conducted in a solvent selected from the group selected from the group consisting of aliphatic hydrocarbons, halogenated aliphatic and aromatic compounds, aliphatic and aromatic nitro compounds and carbon disulfide.

15 15. The process of claim 14, wherein the reaction is conducted in a halogenated solvent.

20 16. The process of claim 14, wherein the halogenated solvent is selected from the group consisting of chlorobenzene, dichlorobenzene, 1,1,2,2-tetrachlorethane, and mixtures thereof.

17. The process of claim 1, wherein the compounds are reacted for a time from about 2 to about 24 hours.

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INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 99/20238

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 C07D251/24

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C07D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>BRUNETTI H ET AL: "DIE SYNTHESE VON ASYMMETRISCH SUBSTITUIERTEN O-HYDROXYPHENYL-S-TRIAZINEN" HELVETICA CHIMICA ACTA, CH, VERLAG HELVETICA CHIMICA ACTA. BASEL, vol. 55, no. 5, 1972, page 1566-1594 XP000651570 ISSN: 0018-019X cited in the application page 1573 -page 1575</p> <p style="text-align: center;">— -/- .</p>	1-17

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"Z" document member of the same patent family

Date of the actual completion of the international search

18 November 1999

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